

Date: Thursday, 24/07/2008 8:20:48 AM
 User: Melanie Fauteux

Process Sheet

Customer: : CU-DAR001 Dart Helicopters Services Drawing Name : FWD ADJUSTABLE BLADE SUPPORT ASSY
 Job Number : 40606 -2 Part Number : PB674300111
 Estimate Number : 13435 Drawing Number : B6743001 P.8
 P.O. Number : Project Number : N/A
 This Issue : 24/07/2008 S.O. No. : Drawing Revision : B1
 Prsht Rev. : NC Material :
 First Issue : 17/07/2008 Type : LARGE FAB ASSY Due Date : 24/07/2008 Qty: 5 Um: Each
 Previous Run :
 Written By :
 Checked & Approved By : MF 08-07-24
 Comment : Est Rev:A 08-06-26 new issue DD verified by:ec

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001247	Inner Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 Inner Tube
 batch: 340689

08-07-22 5

2.0	PB6743001249	Inner Tube Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 Inner Tube Bushing
 batch: 10537

08-07-22 5

3.0	PB6743001253	Gusset
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 Gusset
 batch: 340045

08-07-22 5

4.0	PB6743001254	Gusset
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 Gusset
 batch: 340053

08-07-22 5

5.0	PB674300167	PB67-43001-67
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 PB67-43001-67
 batch: 340243

08-07-22 5

1. 2. 3. 4. 5.
1. 2. 3. 4. 5.
1. 2. 3. 4. 5.
1. 2. 3. 4. 5.
1. 2. 3. 4. 5.

1. 2. 3. 4. 5.
1. 2. 3. 4. 5.
1. 2. 3. 4. 5.
1. 2. 3. 4. 5.
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Job Number: 40606

Part Number: PB674300111

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- make a 0.090" chamfer in the 1.00" hole before welding

2- assemble parts and weld as per dwg

Handwritten: 08-07-22 5

7.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Handwritten: 08-07-24 (5)

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 08/08/26 (18) 08-07-29 (5)

9.0 MS124780 HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

HELICAL INSERT

Handwritten: 17935, 08-07-29 5

10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush in area of PB67-43001-249 only

2- tap drill for helicol

3- install helicol insert as per dwg

Handwritten: 08-07-29 (5)

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 08/07/29 (5)

12.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten: N/A

13.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Handwritten: M 102316 (5x)

1- MASK TUBE FROM BASE TO GUSSET

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

Handwritten: 08-07-31 (5) m.f. 08/07/31

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Part Number: PB674300111

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:30
320°F
3:00

m-h

08/07/31

(5X)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL

08/07/31

(5)

15.0

PB674300169

90 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

90 Degree Cover Plate

batch: 40069

08.08.26

5

16.0

PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

PB67-43001-83

batch: 40096

08.08.26

5

17.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

Screw

batch: 18836

08.08.26

5

18.0

NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

WASHER

batch: 108700

08.08.26

5

19.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- match drill cover to existing holes in support

2- assemble as per dwg

08.08.26

5

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Seq. #:

Machine Or Operation:

Description :

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/26 63

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

39952

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/26 12

Job Completion



u 08.08.26

